

Work Order ID 150874

September 08, 2016 11:27:34 AM

150874

Page 1

Item ID: D407-559-115 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible
Start Date: 9/8/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/16/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: SK Date: SEP 08 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9624	REV A	SEP 08 2016	DAS 6 9-89			DAS 21 9-89		160908	
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork		Photocopy blue file and type labels per PPP D407-559-115 CHG001							
			chgoz						
151	Pick Kit	0.00							
151									
Packaging	Memo	0.00							
Packaging									
160	QC4- 100% Inspect kits for completeness	0.00							
160									
QC	Memo	0.00							
Quality Control									

Ship - sold 50127706.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 150874

September 08, 2016 11:27:34 AM

150874

Page 2

Item ID: D407-559-115

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop *NS2*

Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 9/8/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 9/16/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <i>Egob3</i>	0.00							
170									
Packaging	Memo	0.00				<i>1x</i>	<i>DAS 28 9-89</i>		SEP 09 2016
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00					<i>DAS 21 9-89</i>		SEP 12 2016
Quality Control									

*DAS
21
9-89*

SEP 12 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

September 08, 2016 11:27:33 AM

Page 1

Work Order ID: 150874

150874

Parent Item: D407-559-115

D407-559-115

Parent Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 9/8/2016

Required Date: 9/16/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-07-23 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2274		Manufactured	No				Each	121.0000		12			
-------	--	--------------	----	--	--	--	------	----------	--	----	--	--	--

D2274

Radius Block

**

PC

DAS
9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

FG	12	
----	----	--

86855	12	
-------	----	--

ST006	11	
-------	----	--

144391	11	
--------	----	--

ST012a	98	
--------	----	--

147530	98	
--------	----	--

D2529		Manufactured	No				Each	104.0000		12			
-------	--	--------------	----	--	--	--	------	----------	--	----	--	--	--

D2529

Washer

**

PC

DAS
9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

ST008	80	
-------	----	--

108881	12	
--------	----	--

147569	68	
--------	----	--

ST009	24	
-------	----	--

140554	24	
--------	----	--

D2432-3		Manufactured	No				Each	3.0000		2			
---------	--	--------------	----	--	--	--	------	--------	--	---	--	--	--

D2432-3

206 (24") Bearpaw

**

PC

DAS
9-89

DAS
28
9-89

Location	Loc Qty	Loc Code
----------	---------	----------

ST454a	3	
--------	---	--

139891	1	
--------	---	--

147447	2	
--------	---	--

SEP 09 2016

2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

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Page 2

Work Order ID: 150874

150874

Parent Item: D407-559-115

D407-559-115

Parent Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 9/8/2016

Required Date: 9/16/2016

Start Qty: 1.00

Required Qty: 1.00

D4011-1 Manufactured No

Each 39.0000

6

D4011-1

Clamp, Short

**

PC

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST544

39

145016

39

6

D4012-1 Manufactured No

Each 51.0000

6

D4012-1

Cushion

**

PC

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

133458

5

ST545

46

147643

46

6

AN4-20A Purchased No

Each 130.0000

12

AN4-20A

Bolt

**

PC

DAS
6
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

6

m116419

6

over003

100

m135056

50

m135600

50

ST343

24

m134943

24

12

SEP 09 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

September 08, 2016 11:27:33 AM

Page 3

Work Order ID: 150874

150874

Parent Item: D407-559-115

D407-559-115

Parent Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 9/8/2016

Required Date: 9/16/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0463J

Purchased

No

Each

2,984.000

12

NAS1149D0463.J

Washer

**

PC 

Location

Loc Qty

Loc Code

GA	230
M132035	15
M134508	32
M135056	183
ST260a	2000
M135407	1000
M135530	1000
ST263	754
M134039	24
<u>M135390</u>	730

Each

1,757.000

12

MS21042L4

Purchased

No

MS21042L4

Nut

**

PC 

Location

Loc Qty

Loc Code

FP001	51
m133363	51
GA	424
m133769	116
m135058	308
ST3003	25
m134955	25
ST303	1257
m133769	12
m134055	12
<u>m135297</u>	233
m135470	1000

DAS
28
9-89

12

SEP 09 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 150874

150874

September 08, 2016 11:27:34 AM

Page 1

Item ID: D407-559-115

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: 206L Series/407 Bearpaws - Run-on Landing Wearplate Compatible

Start Date: 9/8/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/16/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

SEP 08 2016

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI 9624	REV A	SEP 08 2016					DAS 21 9-89		SEP 08 2016
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file and type labels per PPP D407-559-115	CHG001							
151	Pick Kit	0.00							
151									
Packaging	Memo	0.00							
Packaging									
160	QC4- 100% Inspect kits for completeness	0.00							
160									
QC	Memo	0.00							
Quality Control									

DAS
21
9-89CHG002
see attachment

PAGE 1 OF 1

Part Number: D407-559-115

Description: BEARPAW INSTALLATION

[illegible]

REFERENCE ONLY

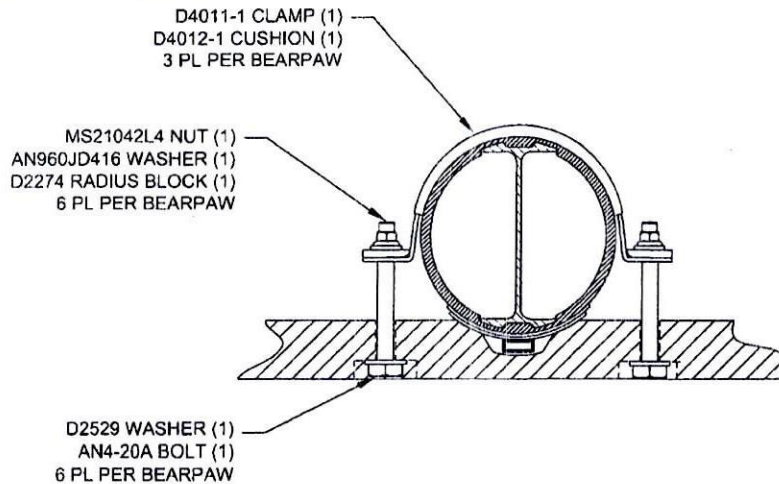


Figure 2 - D4011-1 Clamp Installation

4.0 PARTS LIST

QTY -115	PART NUMBER	DESCRIPTION
	D407-559-115	BEARPAW INSTALLATION
12	D2274	RADIUS BLOCK
12	D2529	WASHER
2	D2432-3	BEARPAW
6	D4011-1	CLAMP
6	D4012-1	CUSHION
12	AN4-20A	BOLT
12	AN960JD416	WASHER (NAS1149D0463J)
12	MS21042L4	NUT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 12.07.05
CERT. NO.: SH92-17
ISSUE NO.: 7

DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AP	
CHECKED	<i>[Signature]</i>	DRAWING NO. REV. A
MFG. APPR.	N/A	DSI 9624 SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE SCALE
DE APPR.	<i>[Signature]</i>	BEARPAW INSTALLATION NTS
DATE	12.07.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD